

Work Order ID 157829

Monday, February 27, 2017 8:01:30 AM

157829

Page 1

Item ID: 644.4111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket, Aft Pivot

Start Date: 2/28/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 3/6/2017 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals:

Process Plan:

Date: FEB 27 2017

Tooling:

Date:

Run Start ***NR1***

QC:

DAS
21
9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

644.4100

F2

100

0.01

100

FLOW WATER JET

Waterjet

Memo

0.02

FLOW CNC Waterjet

1-Cut as per Dwg D

Dwg Rev: F2Prog Rev: F2

2-Deburr if necessary

⑦

02/17/2017

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

⑦

02/17/2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.02

Quality Control

MAR 01 2017

130

Form as per dwg

0.03

130

Brake NC

NC BRAKE

Memo

0.18

Brake NC

DAS
30
9-89

MAR 01 2017

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.02

Quality Control

DAS
38
9-89
MAR 02 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Work Order ID 157829

Monday, February 27, 2017 8:01:30 AM

157829

Page 3

Item ID: 644.4111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket, Aft Pivot

Start Date: 2/28/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 3/6/2017 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Outsource process-Anodize per QSI017 4.1.10.1

0.00

150

Outsource4

Memo

84.00

Issue P/O to ATG: 35521

1- Black Anodize as per Dwg, see note 4.

Certification of Conformity is required

7 MAR 08 2017

DAS
13
9-00

160

Receive & Inspect for Damage & Mat'l Certs

0.00

160

Packaging

Memo

0.02

Packaging

7x SP17-03-13

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.02

Quality Control

7

DAS
38
9-00

MAR 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 157829

Monday, February 27, 2017 8:01:30 AM

157829

Page 4

Item ID: 644.4111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket, Aft Pivot

Start Date: 2/28/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 3/6/2017 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

Spray Painting per QSI005 4.2

0.00

180

SprayPaint

Memo

0.23

Spray Painting

1- PRIME AS PER DWG SEE NOTE 4 AND MPP-172

BATCH: 136429

2- PAINT AS PER DWG, SEE NOTE 4 AND MPP-172

BATCH: 136434

7

DAS
41
9-89

17-3-13

190

QC14- Inspect Spray Paint

0.00

190

QC

Memo

0.02

Quality Control

7

DAS
38
9-89
MAR 14 2017

200

Identify as per dwg & Stock Location: GA

0.00

200

Packaging

Memo

0.02

Packaging

7x

MAR 14 2017

DAS
26
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	☐ OTHER : _____					
Misidentified ☐	☐ Past Due						

Work Order ID 157829

Monday, February 27, 2017 8:01:30 AM

157829

Page 5

Item ID: 644.4111

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket, Aft Pivot

Start Date: 2/28/2017 Start Qty: 7.00 ***7***

Cust Item ID:

Required Date: 3/6/2017 Req'd Qty: 7.00 ***7***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.12

Quality Control

17/3/15 

DAS
21
9-89

MAR 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Monday, February 27, 2017 8:01:35 AM

Page 1

Work Order ID: 157829

157829

Parent Item: 644.4111

644 4111

Parent Item Name: Bracket, Aft Pivot

Start Date: 2/28/2017

Required Date: 3/6/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP REV:A 16.12.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.125

Purchased

No

100

sf

32.1000

0.666

4.907368

M2024T3S 125

02/17/02/27

2024-T3 .125 sheet

Location

Loc Qty

Loc Code

MAT021

32.1

M127668

3.7

M136430

28.4

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04489

SHEET 1 OF 1

DWG NO. 644,4100

REV: F

PREPARED BY: J. BECKER

DATE: 04/08/14

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: PIVOT STEP ASSY

APPROVED BY:

ENGR: *[Signature]*

MFG

[Signature]

QC

[Signature]

EFF:

NEXT ORDER

TRANSACTION
A-ADD
R-REVISECODES (TC)
C-CREATE
D-DELETE

REASON: UPDATE NOTE 4, FINISH SPECIFICATION.

NOTES:

1. IDENTIFY ALL PARTS IN ACCORDANCE WITH MPP-120
2. MATERIAL: 2024-T3 ALUMINUM
3. MATERIAL: 6061-T6 ALUMINUM
4. FINISH IAW MPP-172 SECTION 2.1, SECTION 3.1, SECTION 4.1, SECTION 5.2.
5. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH, CUT ID HOLE USING 1/4" GASKET PUNCH
6. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH, CUT ID HOLE USING 5/16" GASKET PUNCH
7. DIMENSION VALUE HAS FINISH COATING OF 6-10 MIL (.006-.010) TAKEN INTO CONSIDERATION
8. ADD ADDITIONAL WASHER UNDERNEATH CASTLE NUTS IF NECESSARY.
9. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 157829 MLS

1702-27

SHEET 1, NOTES IS:

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOMCHANGE CATEGORY
☐ MAJOR ☒ MINORDER REVIEW REQUIRED
☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04286

SHEET 1 OF 1

DWG NO. 644.4100

REV: F

PREPARED BY J. SOTO

DATE: 12/04/2013

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: PIVOT STEP ASSY

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]*

QC

EFF. NEXT ORDER

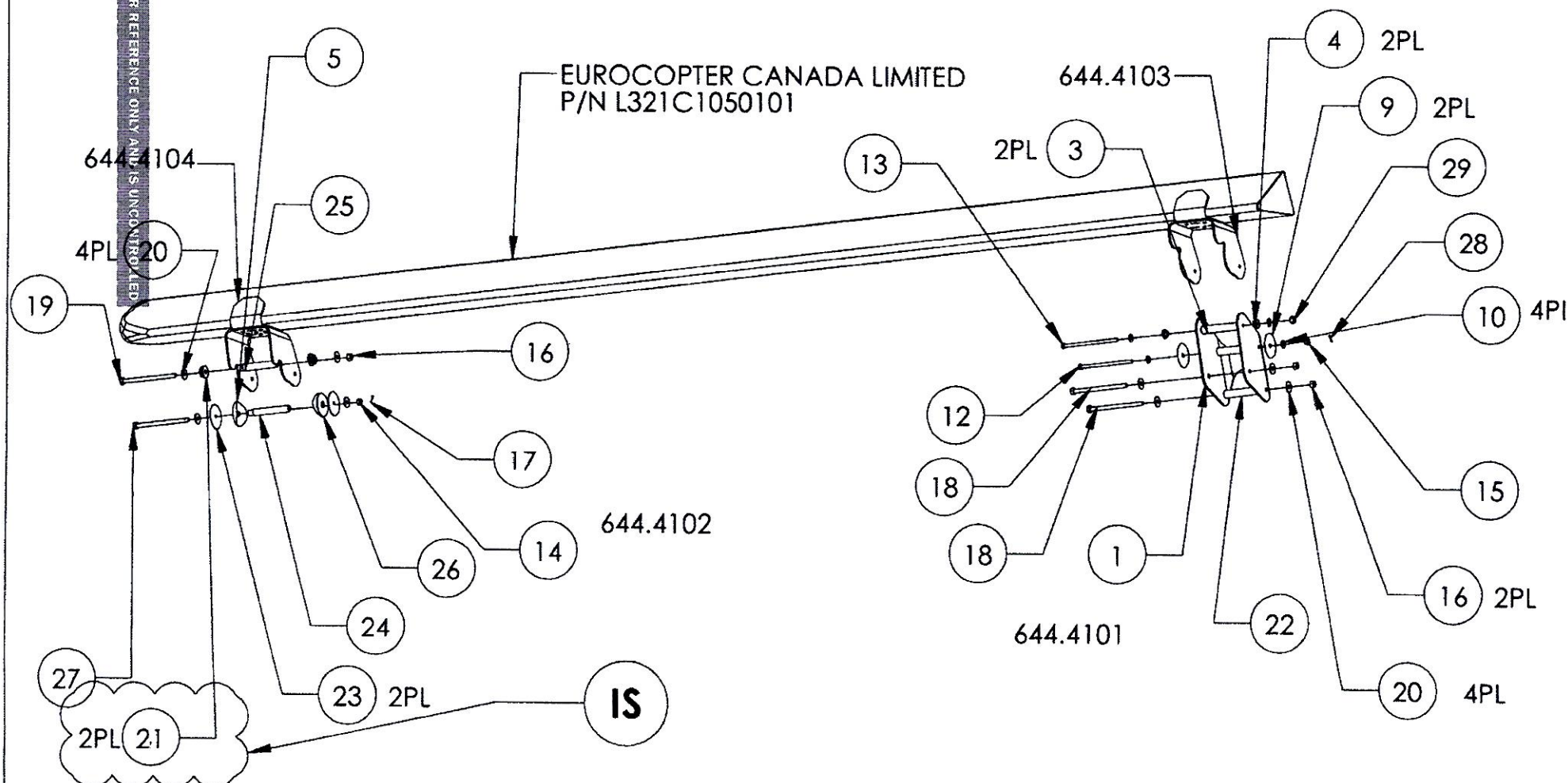
TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: REVISED F/N CALL OUT FROM 22 TO 21

ECR: 13-151

SHEET 1, ZONE D1 IS:

EUROCOPTER CANADA LIMITED
P/N L321C1050101



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

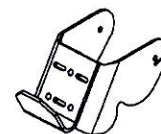
DER REVIEW REQUIRED

☐ YES ☒ NO

NOTES:

-

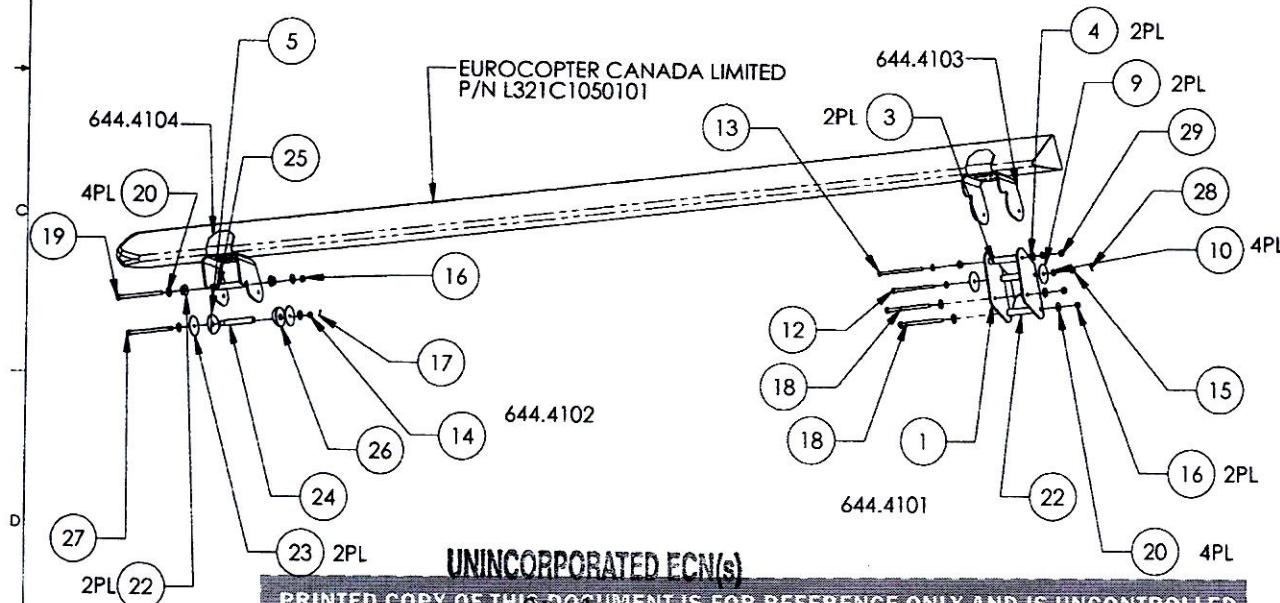
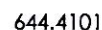
644.4102



644,4103



644.4104



UNINCORPORATED ECN(s)

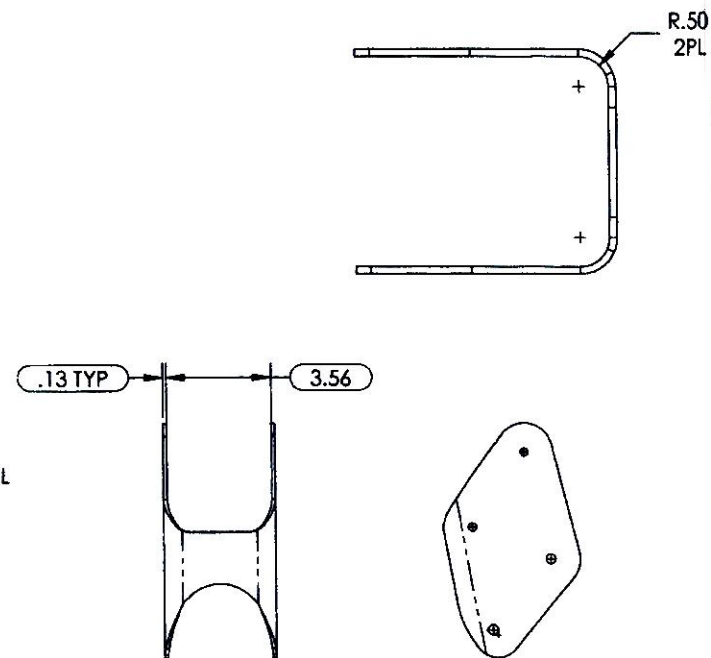
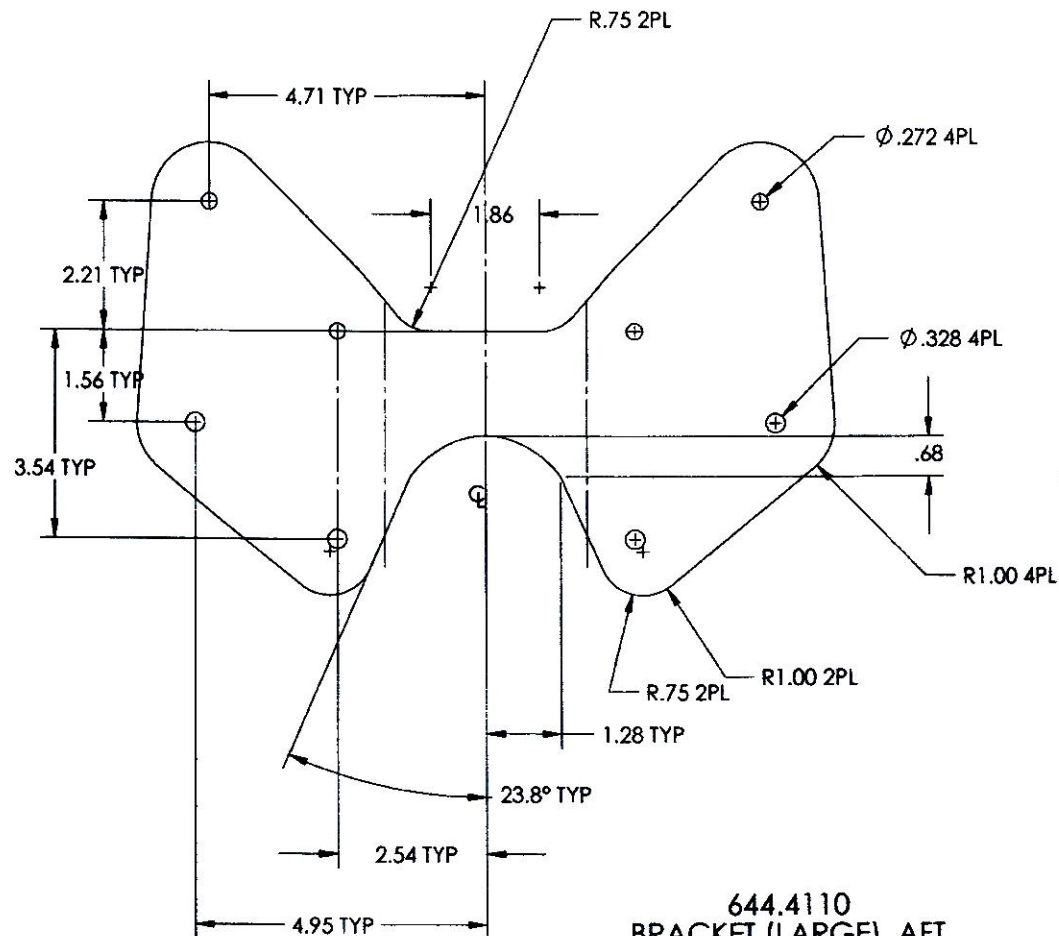
PRINTED COPY OF THIS DOCUMENT IS FOR REFERENCE ONLY AND IS UNCONTROLLED

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECH 01310, 01322, 01332, & 01357.	11-22-65	S. JOSEPH
B	INCORPORATED ECH 01372, 01418, 01796, & 01856.	05-21-67	P. BRAYO
C	INCORPORATED ECH 01908, 07526, 03027.	12-16-10	P. BRAYO
D	INCORPORATED ECH 03111, 03113, 03208, & 03740.	12-10-12	P. BRAYO
E	INCORPORATED ECH 03941.	05-19-13	F. BRAYO
F	INCORPORATED ECH 54006.	2-29-13	F. BRAYO

			1	29	601.3273	LOCKNUT FULL	MS21044N4
			1	28	601.2640	COTTER PIN	MS24665-132
		1		27	601.2328	BOLT, HEX	AN5-45
		1		26	644.4124	WASHER, PIVOT	△△
		1		25	644.4123	FWD CROSS-TUBE BUSHING	△△
		1		24	644.4122	FWD CROSS-TUBE BUSHING	△△
		2		23	644.4121	WASHER, NYLON	△
		1		22	644.4120	SPACER, CROSS-TUBE	△△
		2		21	644.4119	SPACER, FWD STOP	△△
		4	4	20	601.2110	WASHER, FLAT THICK	NAS114PC 0563R
		1		19	601.2250	BOLT, HEX	AN5-50
		2	18	601.2249	BOLT, HEX	AN5-43A	
		1	17	601.3315	COTTER PIN	MS24665-210	
		1	2	16	601.3272	LOCKNUT FULL	MS21044N5
		1	15	601.1435	NUT, HEX CASTLE FULL	AN310-4	
		1	14	601.3270	NUT, HEX CASTLE FULL	AN310-5	
		1	13	601.3407	BOLT, HEX	AN4-47A	
		1	12	601.2434	BOLT, HEX	AN4-45	
6	3		11	601.2326	RIVET, COUNTERSUNK	MS20426AD5-6	
			4	10	601.0863	WASHER, THICK	NAS114PC 0463R
		2	9	644.4118	WASHER, NYLON	△	
1			8	644.4117	BRACKET, PWD PIVOT	△△	
1			7	644.4116	BRACKET (SMALL), FWD	△△	
		1	6	644.4115	BRACKET (SMALL), AFT	△△	
		1	5	644.4114	WASHER, PIVOT	△△	
		2	4	644.4113	SPACER, STOP	△△	
		2	3	644.4112	SPACER	△△	
		1	2	644.4111	BRACKET, AFT PIVOT	△△	
		1	1	644.4110	BRACKET (LARGE), AFT	△△	

1	644.4104	FWD BRACKET ASSY		
1	644.4103	AFT BRACKET ASSY		
	644.4102	PIVOT STEP ASSY		
	644.4101	PIVOT STEP ASSY		
4104 4103 4102 4101	FIND #	PART #	DESCRIPTION	MAT'L SPEC.
QTY		PARTS LIST		
NEXT ASSY (S)		APICAL INDUSTRIES		
644.1800		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-53		
DRAWING APPROVAL		PIVOT STEP ASSY		
S JOSEPH 08-29-05				
CONTRACT NO.				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°		REV CAGE CODE ENG. NO. 644.4100 REV F		
		SIZE B 07/M26 SCALE: NONE SHEET 1 OF 1		

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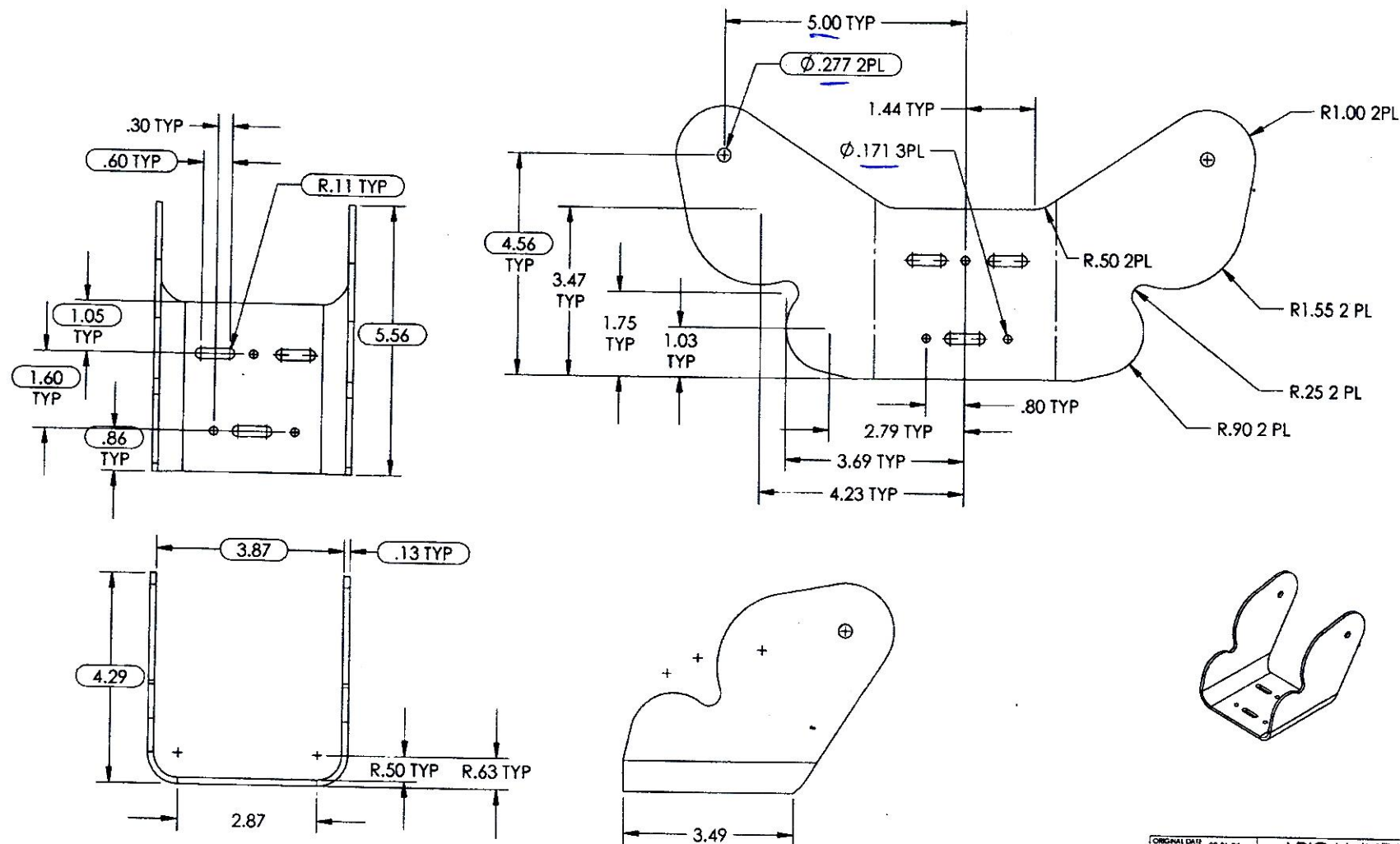


644.4110
BRACKET (LARGE), AFT

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ORIGINAL DATE 08-01-05	APICAL INDUSTRIES
DRAWN BY S. JOSEPH	2608 TEMPLE HEIGHTS DR.
CHECKED BY S. JOSEPH	OCEANSIDE, CA. 92056-3512 (760)724-5300
DATE OF APPROVAL 08-29-05	PIVOT STEP ASSY
CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.005 3 PLACE DECIMALS ±.001 ANGLES ±.5°	REV. F
SHEET 1 OF 16	SCALE NONE

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644.4111
BRACKET, AFT PIVOT

ORIGINAL DATE: 08-01-05		APICAL INDUSTRIES	
DRAWN BY: J. JOSEPH		2408 TEMPLE HEIGHTS DR.	
CHECKED BY: J. JOSEPH		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: J. JOSEPH 08-27-05		PIVOT STEP ASSY	
CONTRACT NO.		REV: F	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°		SHEET: 3 OF 14	SCALE: NONE

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.06 X 45.0°

3.54 $\triangle 7$

$\phi .51$
TYP $\phi .63$

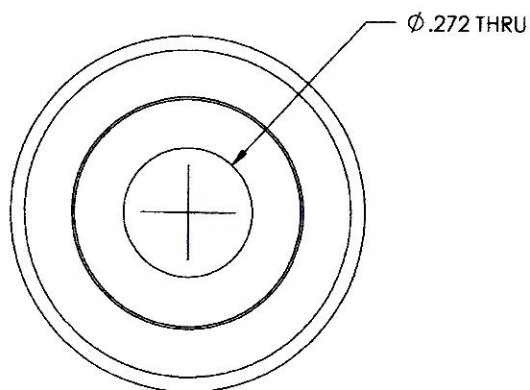
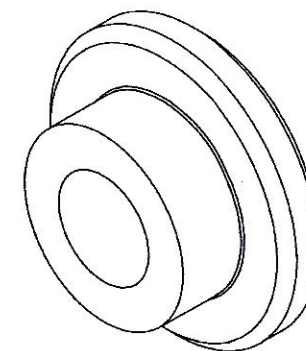
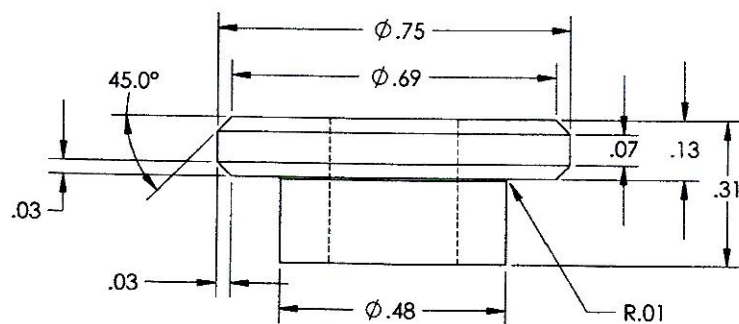
$\phi .272$ THRU

644.4112
SPACER

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ORIGINAL DATE: 05-01-05		APICAL INDUSTRIES	
DRAWN BY: J. JOSEPH		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL: J. JOSEPH 05-21-05		OCEANSIDE, CA 92056-3512 (760) 724-5300	
CHECKED BY:		PIVOT STEP ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS $\pm .010$ 2 PLACE DECIMALS $\pm .020$ ANGLES $\pm .5^\circ$		REV: 07/02/06	REV: F
SCALE: NONE		SHEET 4 OF 16	

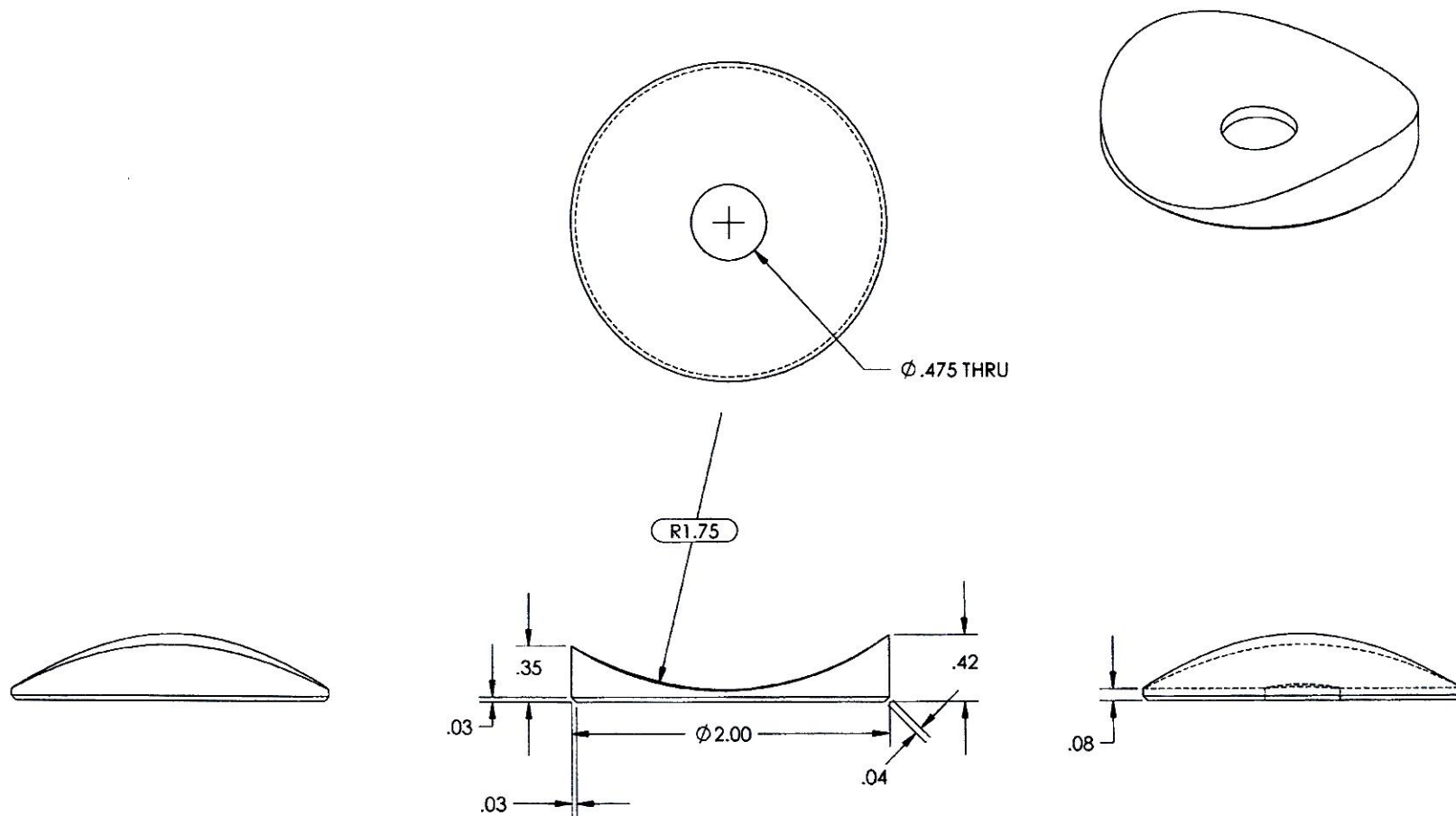
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 644.4100
 SPACER, STOP

ORIGINAL DATE 08-01-05		APICAL INDUSTRIES	
DRAWN BY: D. PARROTT		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: S. JOSEPH		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET 8	REV. F
		DWG. NO. 644.4100	SHEET 5 OF 16

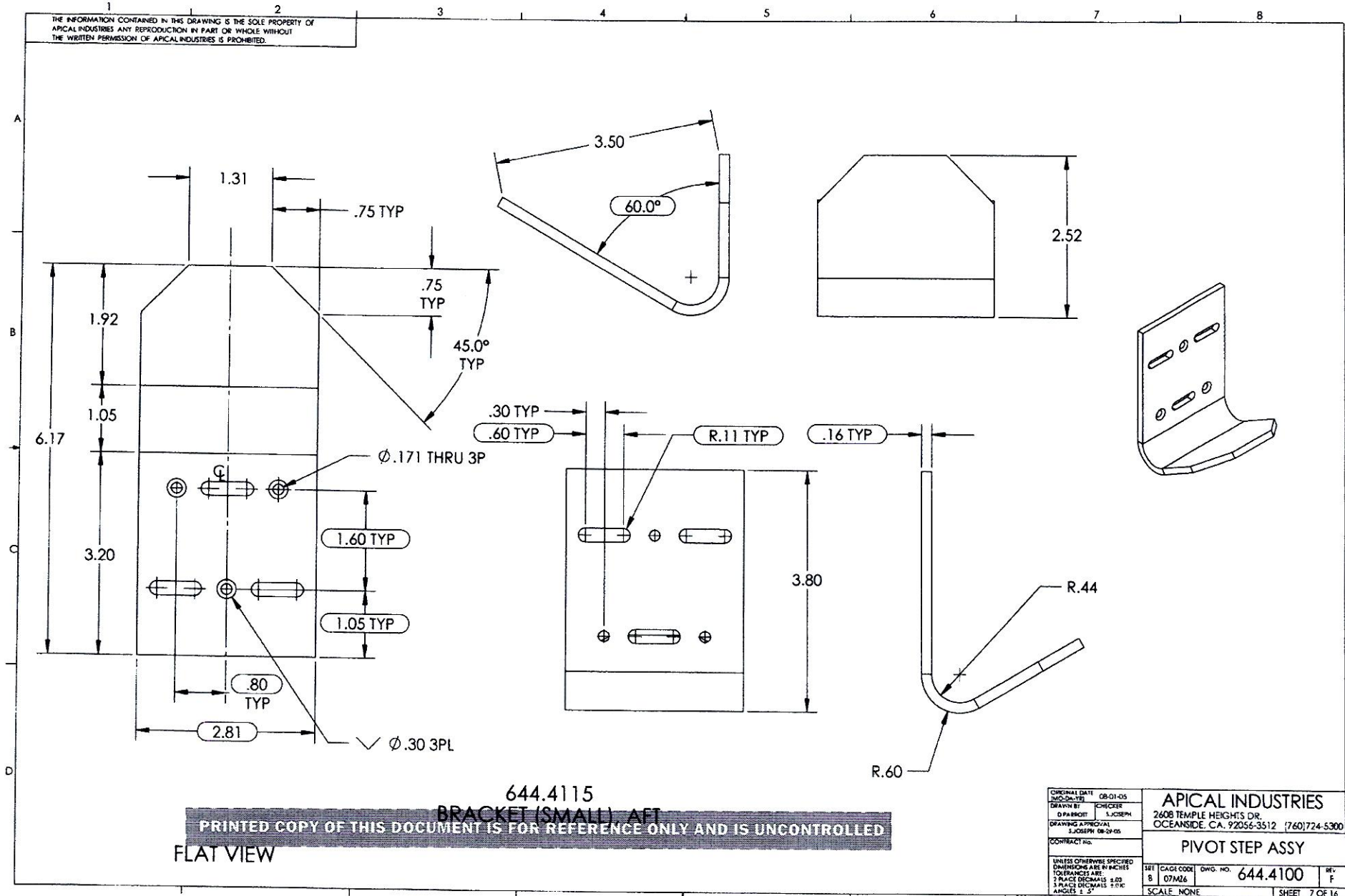
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644.4114
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CHECKED BY S. JOSEPH		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT NO.		REV. F	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS 1.00 3 PLACE DECIMALS 1.010 ANGLES 1/2°		SHEET 6 OF 16	SCALE NONE

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1 2 3 4 5 6 7 8

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A

B

C

D

1.31

.75 TYP

45.0° TYP

2.44

.75 TYP

6.17

3.73

.80 TYP

.80 TYP

1.05 TYP

.80 TYP

2.81

.80 TYP

3.50

60.0°

2.52

.60 TYP

.30 TYP

R.11 TYP

.16 TYP

3.80

R.44

R.60

644.4116
BRACKET (SMALL) FWD

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ORIGINAL DATE	08-01-05
DRAWN BY	J. JOSEPH
CHECKED	J. JOSEPH
DRAWING APPROVAL	J. JOSEPH 08-21-05
CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°	

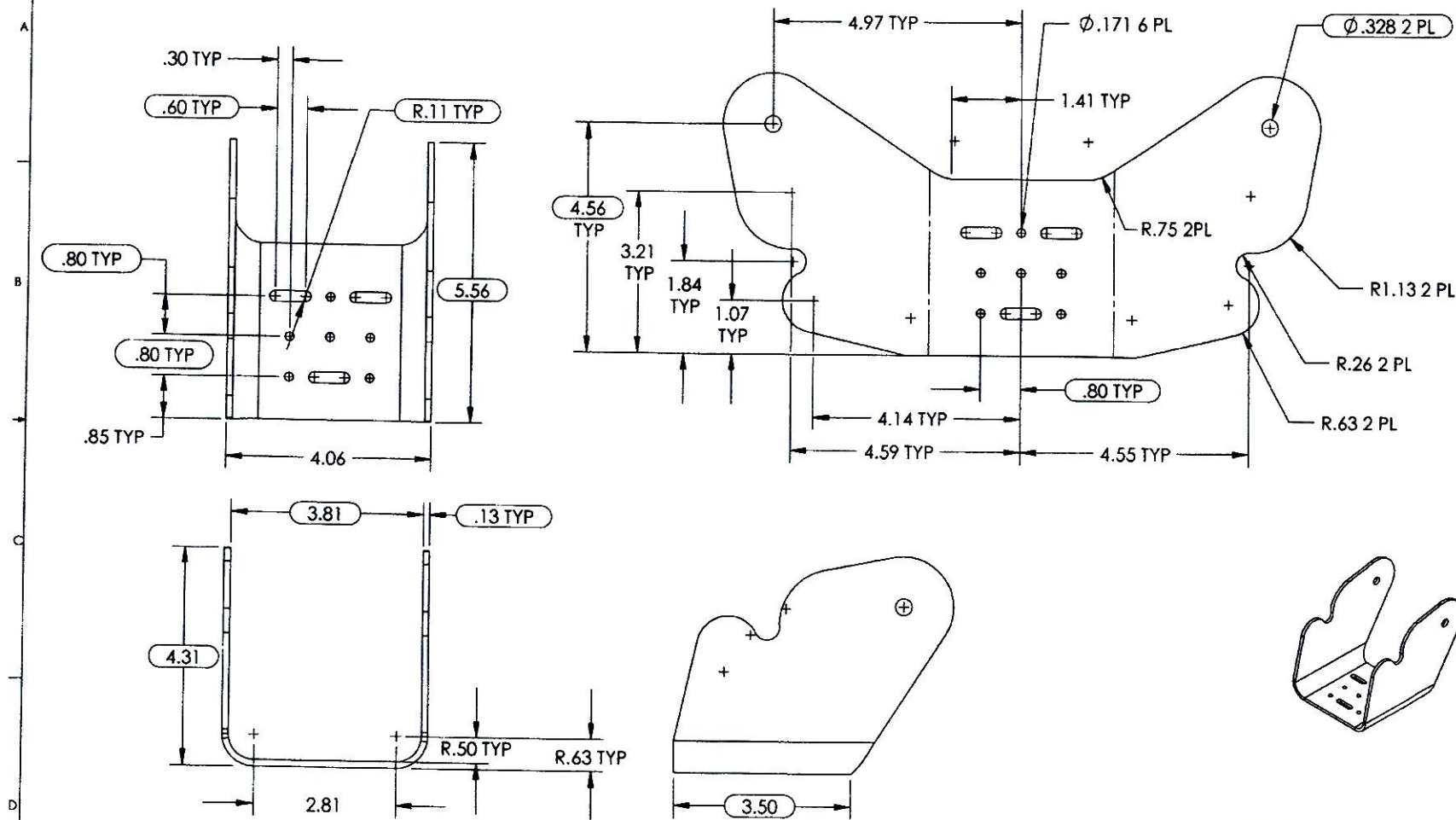
APICAL INDUSTRIES	
2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5312	
PIVOT STEP ASSY	
SHEET	8 OF 1
CAGE CODE	07M26
DWG. NO.	644.4100
SCALE	NONE

BRACKET (SMALL), FWD

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ORIGINAL DATE (MO-DA-YR) 09-01-05 CHECKED BY D. PARROTT J. JOSEPH	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAFTING APPROVAL J. JOSEPH 09-29-05 CONTRACT NO.	PIVOT STEP ASSY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE TO 2 PLACES 2 PLACE DECIMALS = .03 3 PLACE DECIMALS = .010 ANGLES = 2°	SEE SCALE	CAGE CODE 07M16	DWG. NO. 644.4100	REV. F
SCALE NONE			SHEET 8 OF 16	

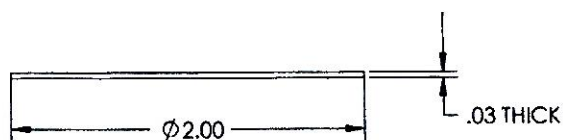
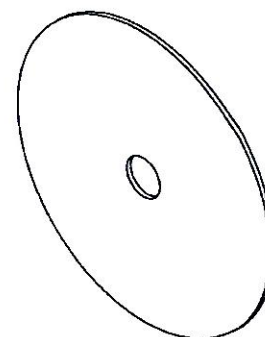
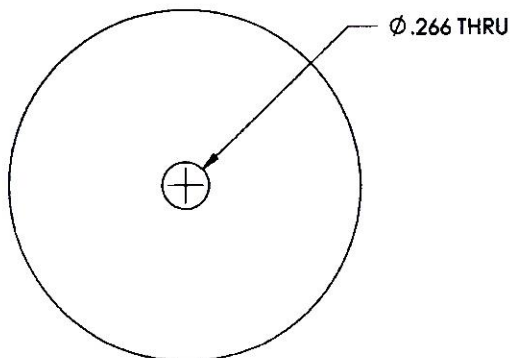
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BRACKET, FWD PIVOT

ORIGINAL DATE: 08-01-05		APICAL INDUSTRIES	
DRAWN BY: CHECKER		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL: S. JOSEPH		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		PIVOT STEP ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS: ±.03 3 PLACE DECIMALS: ±.010 ANGLES: ±.5°		SITE: B	REV. F
SCALE: NONE		DWG. NO. 644.4100	SHEET 9 OF 16

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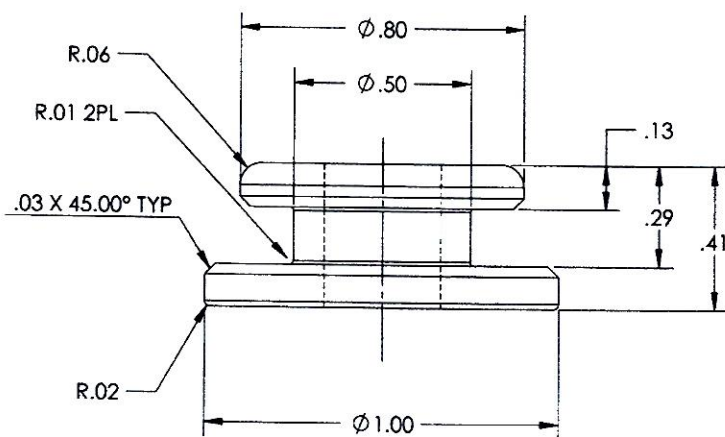
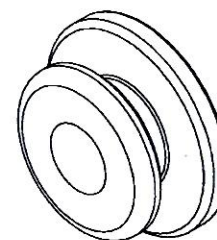
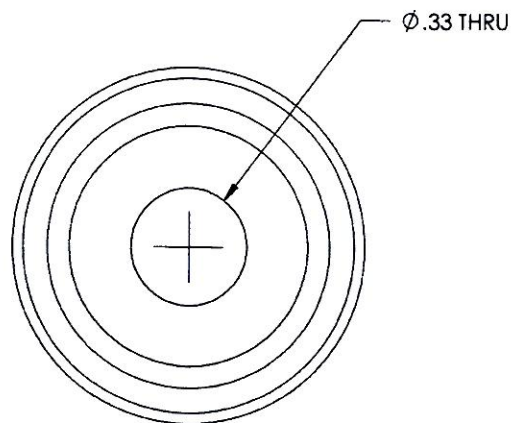


644.4118
WASHER, NYLON

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ORIGINAL DATE 08-01-05		APICAL INDUSTRIES	
DRAWN BY D. J. JOSEPH	CHECKED S. JOSEPH	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SERIAL B	QAGE CODE 07M26
		DWG. NO. 644.4100	REV. F
		SCALE NONE	SHEET 10 OF 16

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644.4118
SPACER, FWD STOP

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ORIGINAL DATE: 08-01-05		APICAL INDUSTRIES	
DRAWN BY: J. JOSEPH		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL: J. JOSEPH 08-24-05		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		PIVOT STEP ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. PLACE DECIMALS ± .03 2. PLACE DECIMALS ± .01 ANGLES ± .5°		SHEET: B	REV: F
SCALE: NONE		SHEET 11 OF 16	

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A

B

C

D

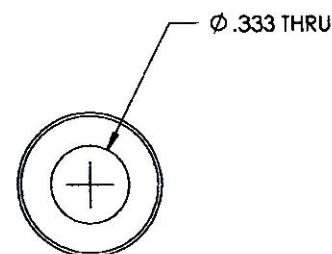
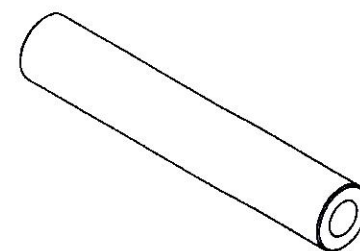
.02 X 45.00°

3.54 $\triangle 7$

$\phi .59$

$\phi .62$

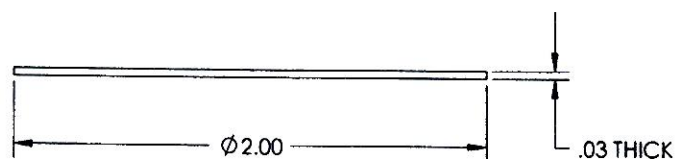
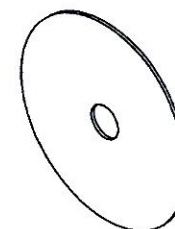
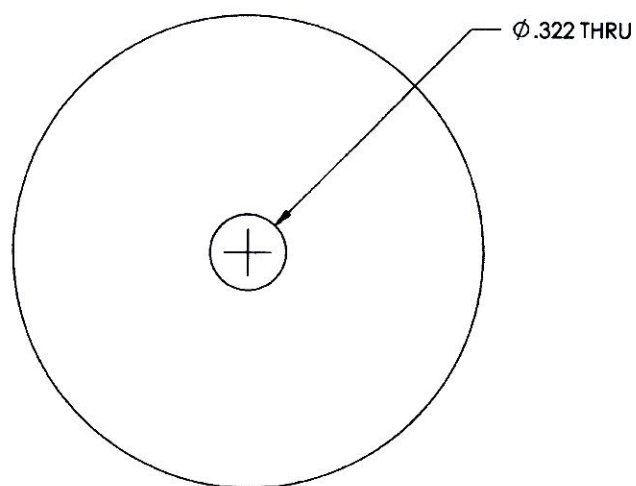
644.4120
SPACER, CROSS-TUBE



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ORIGINAL DATE 08-01-05	APICAL INDUSTRIES	
DRAWN BY J. JOSEPH	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DATE: APPROVAL J. JOSEPH 08-29-05	PIVOT STEP ASSY	
CONTEXT No.	SHEET B	DWG NO. 644.4100
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°	SCALE NONE	SHEET 12 OF 16

1 2 3 4 5 6 7 8
A
B
C
D
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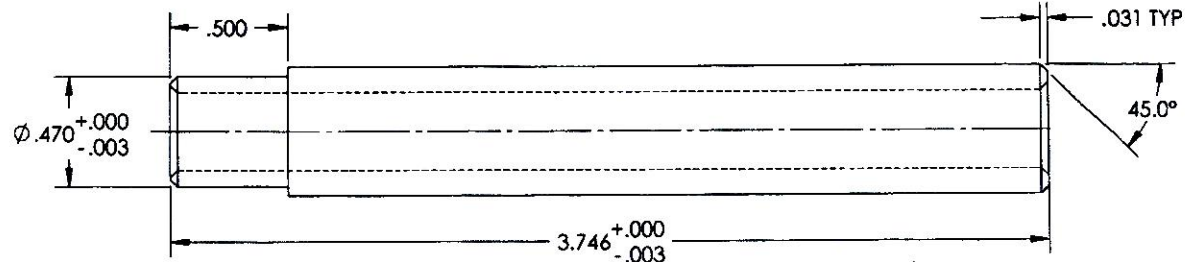
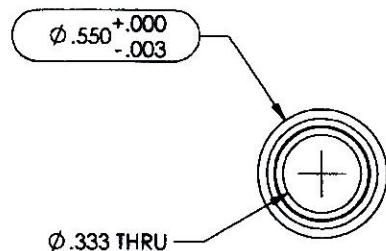
644.4121

WASHER, NYLON

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ORIGINAL DATE (MO-DA-YR)	08-01-05	APICAL INDUSTRIES	
DRAWN BY	D. PARROTT	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5360	
CHECKED BY	S. JOSEPH	PIVOT STEP ASSY	
DRAWING APPROVAL	S. JOSEPH 08-29-05		
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°		REV. NO.	8
		CAGE CODE	07M26
		ENG. NO.	644.4100
		SCALE	NONE
		SHEET	13 OF 16

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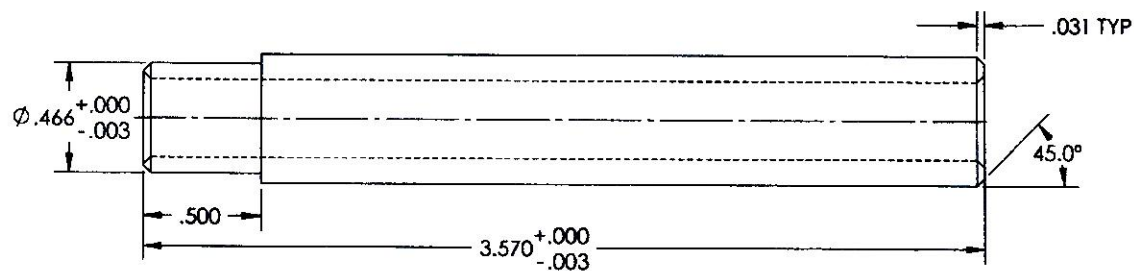
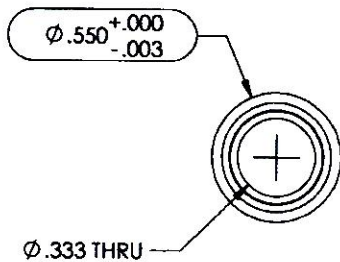


644.4122

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ORIGINAL DATE 08-01-05		APICAL INDUSTRIES	
DRAWN BY D. PARSONS		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY J. JOSEPH		PIVOT STEP ASSY	
DRAWING APPROVAL J. JOSEPH 08-09-05			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .100 3 PLACE DECIMALS .010 ANGLES 1:2		SHEET 14 OF 16	

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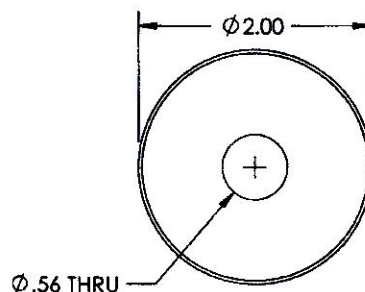
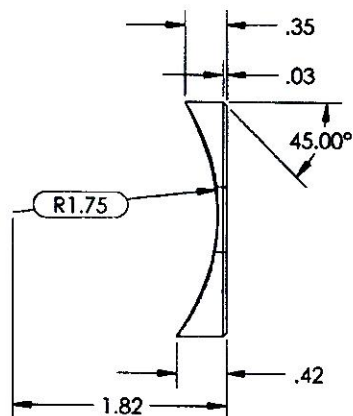


644.4123

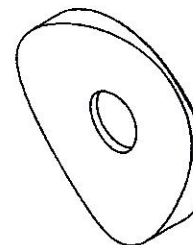
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ORIGINAL DATE (DD-MO-YR) 08-01-05		APICAL INDUSTRIES	
DRAWN BY D. FARRINGTON		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT NO.		REV. F	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.02 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SHEET 07MA26	DWG. NO 644.4100
SCALE: NONE		SHEET 15 OF 16	

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644.4124



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ORIGINAL DATE 08-01-05		APICAL INDUSTRIES	
DRAWN BY J. J. JONES		2608 TEMPLE HEIGHTS DR.	
CHECKED BY J. J. JONES		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL 11/20/04 08/27/05		PIVOT STEP ASSY	
CONTRACT NO.		REV. 1	REV. 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS .010 ANGLES ± .5°		SERIAL CODE B	DWG. NO. 644.4100
SCALE: NONE		SHEET 16 OF 16	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35521**

Purchase Order Date 3/8/2017

PO Print Date 3/10/2017

Page Number 1 of 7

Order From :
A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



MAR 10 2017

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613-446-4544	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
Ship Via:	VENDOR'S TRUCK	FOB	FCA - (Free Carrier)
Ship Acct:			

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	157829	644.4111 BRACKET REV. F	3/13/2017		7.00	\$7.05	\$49.35
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Yes

3/13/2017

HARD ANODIZE AS PER IWA MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK

PART ARE RUSH REQUIRED FOR MARCH 13,

SP17-03-13

Line Total: \$49.35

2	157207	D2348 WEARPLATE REV. C	3/27/2017		10.00	\$12.50	\$125.00
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Yes

3/27/2017

ANODIZE AS PER MIL-A-8625F, TYPE I/IB//C/II/IB, CLASS 2, COLOR BLACK

Line Total: \$125.00

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

3/10/2017



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913041

Date: 13-Mar-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

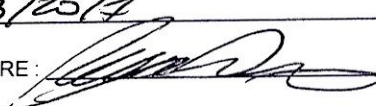
Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
7 ea	Part: 644.4111 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Job: 20768	Rev: F	Line: 1
DATE: 13/03/2017			
CERTIFIED SIGNATURE: 			
RECEIVER SIGNATURE: _____			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.			
MADE IN CANADA.			

SP17-03-B.